

DART 44
5196174

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-013
Job Sheet 195914



Part No: D6101-013

Job Qty: 16 pcs

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 6/25/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	16 pcs	6/25/19	6/25/19	0.00	0.00	Purchasing - 1	JUL 05 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	16 pcs	6/25/19	6/25/19	0.00	0.00	Packaging 2 - 1 - B4B	JUL 05 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	16 pcs	6/25/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
130	Packaging 3-1 - Stock - B4B	16 pcs	6/25/19	0.00 0.00	Packaging 3 - 1 - B4B	BM
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	16 pcs	6/25/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 JUL 08 2019
					QC 21 - SA - 53	9-89

Part Op 100 - Issue P/O: _____ b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) d) Grain direction along 10.100"

Descriptions: length

110 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material certification is attached

120 - (QC6- All purchased or subcontracted products), Ensure Material certification comply to Dwg D6101

130 - (Identify as per dwg & Stock Location: _____), LOCATION: MAT044

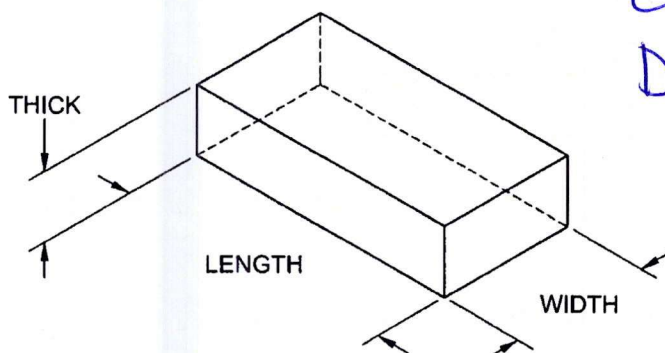
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-013P	Saddle Billet	16 pcs (1 ea)	100-Purchasing	5196154
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-013P	16	0	0
Part Specifications				
Specifications could not be found.				

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SPECIFICATION CONTROL DRAWING

Line 5
D6101-013



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209 Vm

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
B D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED

09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3940599

Ship From:		Sold To:		Ship To:		Deliver To:	
A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
03-JUL-19	ORIGIN	Prepaid		LOCAL FLEET		3940599-5	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description	
5510027	3	752241.MO	2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 10.1")) X 10.1 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 10.1")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No		Part Number	Ordered Qty	Invoice Qty
POHB043615		YOUR ITEM NUMBER: D6101-013	16.00 PCS	16.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 122732150	Mill/Source KAISER ALUMINUM	Heat Number  721597B3	Mech Id	PCS 16	Width (IN)	Length (IN)	Shipped Qty(LBS) 344.7123
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We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned

Date Printed: 03-JUL-2019 04:49:57 PM

SHIP TO: A M CASTLE & CO 14001 ORANGE AVE P.O. BOX 1402 PARAMOUNT, CA 90723
SOLD TO: AM CASTLE & CO- SOLD TO 1420 KENSINGTON RD SUITE 220 OAK BROOK, IL 60523

KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-5108

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4557854

CUSTOMER PO NUMBER: 490142-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 752241	SHIP RUN/LOAD: 104578/33	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1278543-1	SHIP DATE: 29-MAR-2019	ALLOY: 7075	CLAD: BARE	TEMPER: T7351
PRODUCT DESCRIPTION: KaiserSelect Plate				
WEIGHT SHIPPED: 7140 LB (3238.68 KG)	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2079922	GAUGE: 2.5000 IN (63.5000 MM)	DIAMETER/WIDTH: 48.500 IN (1231.9 MM)
			LENGTH: 144.500 IN (3670.3 MM)	

MHU 2318339: LOT 304234B8: 2 pieces;

MHU 2318340: LOT 721597B3: 2 pieces;

Certified Specifications

AMS 4078/RevK
 ASTM B 209/Rev14
 BSS 7055/RevB
 DPS 4.713/RevAK
 GSS16100/RevG/Amd1
 PS 21211/RevP

AMS-QQ-A-250/12/RevA
 ASTM B 594/Rev13
 CMMP 025/RevV
 EAC MS1011/RevE
 MMS 159/RevT

AMS-STD-2154/RevC
 BAC 5439/RevJ
 CSTI 006/RevE
 GAMPS 9101/RevB/AmdSCN1
 PPS 20.04/Rev7

Test Code: 4297

Lot: 304234B8 Cast 800

Drop 13

Test Results

Ingot 4

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.4 : 71.0 (485 : 490)	59.8 : 60.2 (412 : 415)	12.7 : 12.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.9 Min	42.3 Max
(MS/M) :	24.3 Min	24.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.08	0.18	1.4	0.04	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.03



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-013
DATE: JUL 5 2019

PO / BATCH NO.: POHB043615/
S196154

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 16 PCS
QUANTITY INSPECTED: 16 PCS
QUANTITY REJECTED: -

THICKNESS ORDERED: 2.5"
THICKNESS RECEIVED: 2.5"
SHEET SIZE ORDERED: -
SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	Y ☒ N ☐	
CORROSION	Y ☒ N ☐	
CORRECT GRAIN DIRECTION	Y ☒ N ☐	
CORRECT MATERIAL PER M-DRAWING	Y ☒ N ☐	ASIM B209
CORRECT THICKNESS	Y ☒ N ☐	
PHOTO REQUIRED	Y ☒ N ☐	
CORRECT REF # TO LINK CERT	Y ☒ N ☐	HT: 781597B3
CORRECT MATERIAL IDENTIFICATION	Y ☒ N ☐	
CORRECT M# ON THE MATERIAL	Y ☒ N ☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☐ N ☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☐ N ☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____	DAS 81 9-89	SIGNED OFF BY: _____
DATE: JUL 05 2019		DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043615



Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: POHB043615
PO Date: 6/3/19
Due Date: 6/24/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-06-04

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		D6101-001P	72746	7075-T7351 2X6X6.25 AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	6/24/19	20 pcs	20 pcs Vm	20 pcs	\$29.57/pcs	\$591.40
2		D6101-003P	72742	7075-T7351 2X6.25X7.875 : Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	6/24/19	20 pcs	20 pcs Vm	20 pcs	\$38.82/pcs	\$776.40



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

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PURCHASE ORDER

POHB043615



Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
3		D6101-005P	72744	7075-T7351 8.25X5.0X2.5 : Various STC's AS PER DWG.D6101 REV.B SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00" LENGTH MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	6/24/19	40 pcs	40 pcs Vm	40 pcs	\$40.54/pcs	\$1,621.60
4		D6101-007P	72743	7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A- 250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	6/24/19	40 pcs	40 pcs Vm	40 pcs	\$61.72/pcs	\$2,468.80
5		D6101-013P	72745	Saddle Billet : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A- 250/12) SIZE: 10.100" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 10.100" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	6/24/19	16 pcs	16 pcs Vm	16 pcs	\$80.47/pcs	\$1,287.52
6	195920	D6102-013P		6061-T6 7.0X6.5X2.0 : Various STC's	Firmed	-	6/24/19	12 pcs	12 pcs Vm	12 pcs	\$31.65/pcs	\$379.80



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER

POHB043615



Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
7	195921	D6103-003P		Round Alum Billet : Various STC's AS PER DWG D6103 REV. B MATERIAL: 7075-T7351 AS PER QQ-A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	6/24/19	20 pcs	20 pcs 22 pcs vm	20 pcs	\$60.40/pcs	\$1,208.00
8	195922	D6104-003P		17-4 SS Roundbar 3.25"Od : Various STC's	Firmed	-	6/24/19	10 pcs	10 pcs 10 pcs vm	10 pcs	\$26.70/pcs	\$267.00
Grand Total:												\$8,600.52

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Handwritten signature and date:
JUN 06.04.19.

Plex 6/3/19 11:09 AM Dart.Guerin.Kimberley